

Work Order ID 138578

Tuesday, November 03, 2015 10:45:21 AM

138578

Ship Dec 11

Page 1

Item ID: D4628-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Liner, Outboard
Start Date: 11/3/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/3/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLS Date: NOV 03 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4628	A

100 0.00

100

Waterjet
FLOW CNC Waterjet

Memo

1-Cut as per dwg D4628
Prog rev: A
Dwg rev: A

2-Deburr as per dwg

0.01

(1) 02/15/11/10

110 0.00

110

QC
Quality Control

Memo

QC2- Inspect parts off machine FAI/FAIB

0.00

(1) 02/15/11/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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 Required Date: 11/3/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00				①			DAS 38 9-89 NOV 10 2015
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							DAS 6 9-89 NOV 12 2015
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							MCS NOV 12 2015
Quality Control									

MCS NOV 12 2015

DQA: _____ Date: _____

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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

Tuesday, November 03, 2015 10:45:25 AM

Page 1

Work Order ID: 138578

138578

Parent Item: D4628-5

D4628-5

Parent Item Name: Liner, Outboard

Start Date: 11/3/2015

Required Date: 11/3/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA 12.03.29 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased		No		100	sf	2,718.120	6.63	6.978947			

MKYD6185S 080-P3-52068

Kydex steel grey (52"x96"-.080)

12/15/14

Location	Loc Qty	Loc Code
SHED	1180	
m129546	347	
m129760	347	
m130383	486	
therm	1538.12	
121902	543.15	7.2
122181	994.97	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

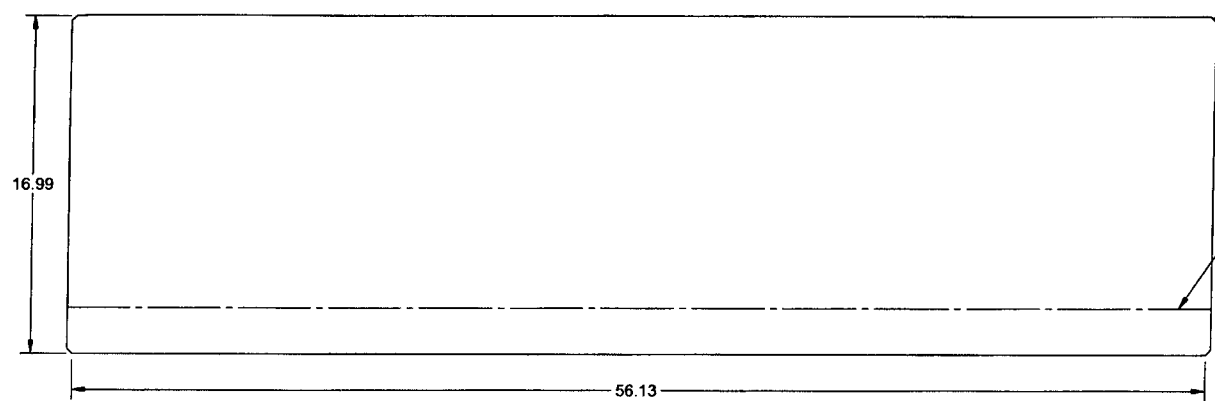
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	

8 7 6 5 4 3 2 1

D
C
B
A



0.25 X 45°
CHAMFER
TYP

BEND LINE
REF

0.080
REF

R2.9
REF

D4628-5 LINER, OUTBOARD

D4628-5 LINER, OUTBOARD
FORMED DURING ASSY
REF ONLY

RELEASED
2012-04-04

NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERRED) OR STEEL GREY (ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-5" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 3.35 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	B	D4628	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	J	LINER	NTS
DATE	12.03.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1